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D3319-3

Job Sheet 200643



Part No: D3319-3

Job Qty: 6 pcs

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 9/27/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs	9/27/19	9/27/19	0.17	1.40	Waterjet - Flow		09/19/13
110	QC 2	6 pcs	9/27/19	9/27/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		09/19/13
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

120 QC 8	6 pcs	9/27/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	SFP 1 6 2019
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
140 Small Fab - Brake NC - B4B	6 pcs	9/27/19	0.25 0.40	Small Fab - Brake - 1 - B4B	DAS 30 SEP 23 2019
				Small Fab - Brake - 2 - B4B	9-89
				Small Fab - Brake - 3 - B4B	
150 QC 5	6 pcs	9/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	SFP 2 4 2019
				QC 5 - 61	
				QC 5 - 81	
160 Automated Welding - B4B	6 pcs	9/27/19	0.00 1.91	Automated Welding - 1 - B4B	4 H.N. W.L.
170 QC 10	6 pcs	9/27/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	

180 QC 5	6 pcs	9/27/19	0.00 0.00	QC 10 - 50	R
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	R
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Spray Paint - 2 - B4B	6 pcs	9/27/19	0.00 0.60	Spray Paint - 1 - B4B	A8 19-10-2
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 3	6 pcs	9/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	OCT 07 2019 40 9-89
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
210 Packaging 3-1 - Stock - B4B	6 pcs	9/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	ST260B
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	

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				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	7 6 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21 ✓
					QC 21 - SA - 70
					QC 21 - SA - 53

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9-89

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Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

140 - Form using DT8326 & DT8261 as per Dwg D3319

150 - (QC5- Inspect part completeness to step on W/O)

160 - 8259 Hardcoat Rod

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 5213093

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____) Identify on inside surface using a permanent fine point marker with the following:

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	19.5000 sf (3.25 ea)	100-Waterjet - Flow - 1	5204108

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	20	114	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499		
3	Wearplate	0.316inches ± 0.010	0.326 0.306		
4	Wearplate	0.607inches ± 0.010	0.617 0.597		
5	Wearplate	2.940inches ± 0.030	2.970 2.910		
6	Wearplate	2.690inches ± 0.030	2.720 2.660		
7	Wearplate	3.527inches ± 0.010	3.537 3.517		
8	Wearplate	4.520inches ± 0.030	4.550 4.490		
9	Wearplate	5.063inches ± 0.010	5.073 5.053		
10	Wearplate	6.160inches ± 0.030	6.190 6.130		
11	Wearplate	0.600inches ± 0.030	0.630 0.570		
12	Wearplate	8.690inches ± 0.010	8.700 8.680		
13	Wearplate	30.790inches ± 0.010	30.800 30.780		
14	Wearplate	52.880inches ± 0.030	52.910 52.850		
15	Wearplate	62.770inches ± 0.010	62.780 62.760		
16	Wearplate	74.420inches ± 0.010	74.430 74.410		
17	Wearplate	75.520inches ± 0.030	75.550 75.490		
18	Wearplate	0.050inches ± 0.010	0.060 0.040		

Plex 9/13/19 12:54 PM dart.lacelle.linda